

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009323**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin, Li Hong Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY # 10

This QA Inspector randomly observed the following work in progress.

Flux cored arc welding process of weld joint 82A/B located on PCMK NSTL3-3C/K. Welder is identified as 040345ZPMC QC is identified as Jiang Xi Bo. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

Flux cored arc welding process of weld joint 3B located on PCMK NSD1-SPSA3-56. Welder is identified as 040533ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

BAY # 11

SMAW welding process of weld joint 58A located on PCMK ESTL4-2B/L. Welder is identified as 049099ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-P4.

# WELDING INSPECTION REPORT

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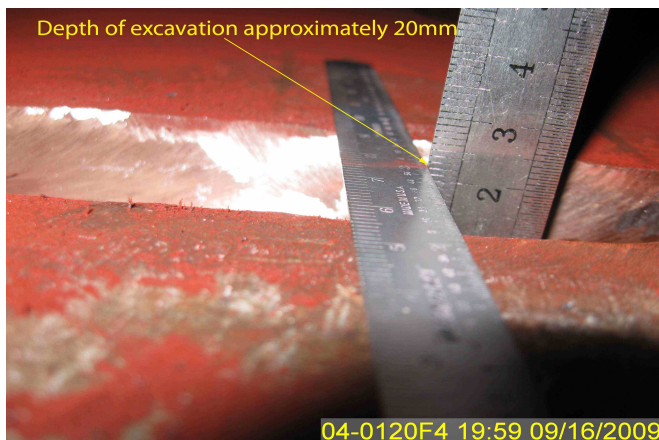
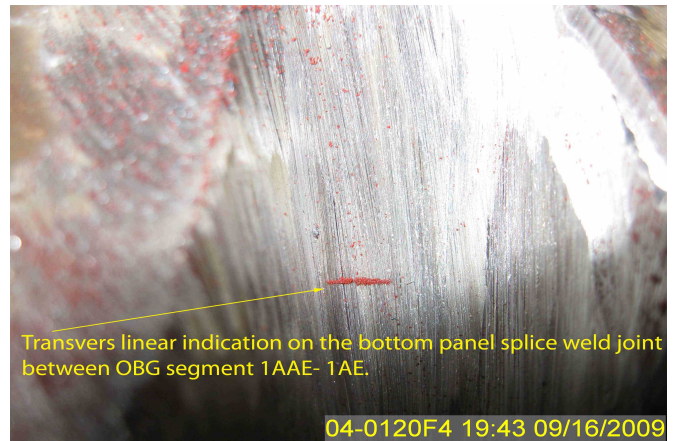
SMAW welding process of weld corner joint between skin plate C and D located on West tower lift #3. The welder is identified as 040669ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair. The critical report identified as T-CWR225 and ZPMC ultrasonic report identified as T787-UT-2177R4

## TRIAL ASSEMBLY YARD

### OBG SEGMENT-1AAE-1AE

This Quality Assurance Inspector (QA) observed that the contractor excavated the bottom panel splice joint between OBG segments 1AAE- 1AE (OBE1A-003) at two locations. This excavations located approximately 2250 and 3000 from bike path side longitudinal diaphragm. The excavation measured approximately 200x40mm and 20mm in depth. This QA Inspector observed ZPMC NDT personnel performed Magnetic particle inspection over excavation area during the time of magnetic particle inspection this QA noted that ZPMC found a transverse linear indication approximately 10mm in length. This linear indication located approximately 2200mm from bike bath side longitudinal diaphragm. Regarding this issue informed to task leader and other supervisor. See the attached photos for additional information.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant
<b>Reviewed By:</b>	Clifford,William

Quality Assurance Inspector

QA Reviewer